

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007717**Date Inspected:** 16-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Qing, Li Lin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following in the trial assembly area:

Segment 2AW, south side, between panel points 14/14.5:

ZPMC workers installed a shim plate between angle clip and deck plate stiffener using a mechanical jack to open the gap enough to allow room for the shim.

Bay 10

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 10:

SAW welding of weld joints SSD1-FCSA4-1A/C-55A, 54A, 53A located on PCMK south tower, lift 4, skin C.

Welder was identified as 201750. ZPMC QC was identified as CWI Wang Chuan Qing (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Zong Yi, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2221-B-U3c-S-2. Also at this location and appearing to be monitoring the welding operations was ABF Representative Xiao Jun Peng.

SAW welding of weld joint SSD1-FDSA4-1C/C-43B located on PCMK south tower, lift 4, skin D. Welder was

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identified as 040489 ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Zong Yi, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2221-B-U3c-S-2. Also at this location and appearing to be monitoring the welding operations was ABF Representative Xiao Jun Peng.

Bay 11

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 11:

SAW welding of weld joint ESD1-FBSA4-2A/C-57A located on PCMK east tower, lift 4. Welder was identified as 044560. ZPMC QC was identified as CWI Li Lin (QC2). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-U3c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above, and this QA Inspector, George Goulet, asked each welding QC if all the welding variables observed by QC appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. Each welding QC showed this QA Inspector, George Goulet, that each welding QC was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all each welding QC observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
